

SMALL FAB / 03/5.FAB



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-2706-00-03

Job Sheet 180108



Part No: RBE350A94-2706-00-03

Job Qty: 40 ea

Part Name: Pin



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 7/30/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-16 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	7/30/18	7/30/18	0.00	0.00	Start Up Small Fab-2		MCC
110	Small Fab	40 pcs	7/30/18	7/30/18	0.00	20.00	Small Fab-3		MCC DAS
120	QC	40 pcs	7/30/18	7/30/18	0.00	0.00	QC5		38
121	Outsource	40 pcs	7/30/18	7/30/18			GRO002-VC	10	9-89-24
123	Packaging	40 pcs	7/30/18	7/30/18	0.00	0.00	Packaging2		AUG 3 1 2018
125	QC	40 pcs	7/30/18	7/30/18	0.00	0.00	QC6		9-89
127	Small Fab	40 pcs	7/30/18	7/30/18	0.00	0.00	Small Fab-8		18-08-31
129	QC	40 pcs	7/30/18	7/30/18	0.00	0.00	QC5		18-8-31
130	Packaging	40 pcs	7/30/18	7/30/18	0.00	0.00	Packaging3-1		18-08-31
140	QC21-SA	40 Ea	7/30/18	7/30/18	0.00	0.00	QC21		18-08-31

Part Op 90 - see engineering sign off for lanyard

Descriptions: 110 - Assemble as per DWG. Sheet 2 - Loctite 680 B 138837 Exp: 11/19
 121 - Issue P/O to Groupe Altech; PO 240521 - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required
 123 - Receive
 127 - Fabricate lanyard 2.75 inch and Assemble as per DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	80 Ea (2 ea)	90-Start up Operation	
91595A142	Dowel Pin Ø3mm x 40mm	40 Ea (1 ea)	90-Start up Operation	5093325
CL-2-C	Lanyard Wire	16.6400 ft (.416 ea)	90-Start up Operation	
NAS 1756-12	Remove Before Flight	40 (1 ea)	90-Start up Operation	
RBE350A94-2706-00-03A	Pin Shaft	40 Ea (1 ea)	90-Start up Operation	5082715

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	80	682	0
	91595A142	40	96	0
	CL-2-C	17	312	0
	NAS 1756-12	40	0	0
	RBE350A94-2706-00-03A	40	36	0



Container No: S104619



Part: RBE350A94-2706-00-03

Job No: 180108

Serial No/Batch: S104619

Revision: 6

Inspector:

Exp Date:

Instructions:

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/23/18

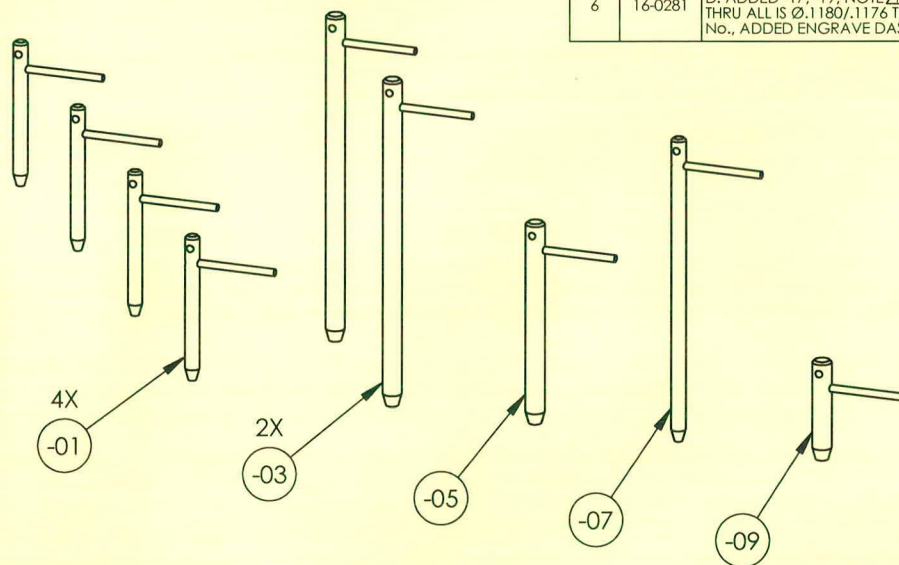
Part Specifications

Specifications could not be found.

Plex 6/28/18 4:13 PM dart.logan.david

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED PER HELI PRODUCTS TOOLS.	9/11/2009	WP	DW
2		ADDED ONE MORE -03 PIN, FLAG AND CABLE TIE.	6/14/2010	WP	DW
3		MOVED LENGTH B DIMENSION TO Ø.118in. HOLE CENTERLINE & ADDED 1.5mm TO -01 THRU -09 PINS IN TABLE. ADDED A TOLERANCE TO Ø.118in HOLE TO ACHIEVE A LIGHT PRESS FIT FOR -11. CH'D HOLE FROM Ø.118 TO Ø.113 FOR CABLE TIES. END OF PIN PER S.E.	12/15/2010	RJC	RW
4		CORRECTED PIN VIEW SHEET 1 AND CH'D Ø.113 [Ø2.9mm] HOLE TO Ø.118 [Ø3.0mm] PER G.E.	5/9/2012	RJC	GE
4A		CH'D T/N WAS RBEA94-2706-00 IS RBE350A94-2706-00.	11/6/2013	RJC	RW
5	15-0120	UPDATED TO NEW DRAFTING STANDARDS. CH'D TOLERANCE BLOCK WAS .XXX ± .004 IS .XXX ± .005. ADDED P/N'S -01A, -03A, -05A, -07A, -09A. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	5/26/2015	DPD	JAG
6	16-0281	UPDATED TO DRAFTING STANDARD. -01, -03, -05, -07, -09 ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D. ADDED -17, -19, NOTE Δ. -01A, -03A, -05A, -07A, -09A CH'D DIM WAS 2X Ø.118 ± .001/-0.000 THRU ALL IS Ø.1180/.1176 THRU ALL (P.F. -11). ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No., ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG

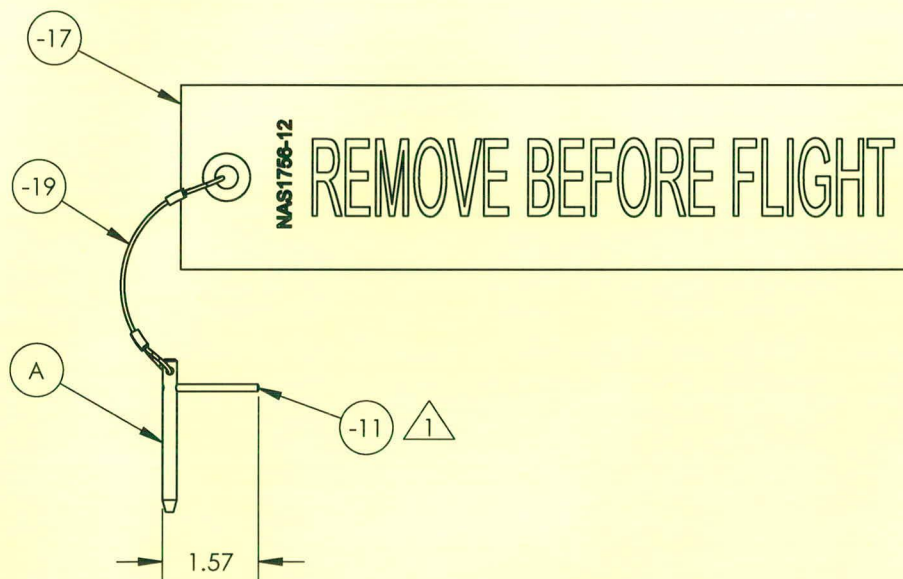
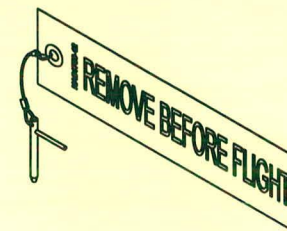


ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				X		-01	4	PIN			2
				1		-01A		PIN SHAFT	O-1	Ø6mm X 3 FT (MCMASTER-CARR #88625K65) MODIFIED	3
			X			-03	2	PIN			2
			1			-03A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMASTER-CARR #88625K67) MODIFIED	3
		X				-05	1	PIN			2
		1				-05A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMASTER-CARR #88625K67) MODIFIED	3
	X					-07	1	PIN			2
	1					-07A		PIN SHAFT	O-1	Ø6mm X 3 FT (MCMASTER-CARR #88625K65) MODIFIED	3
X						-09	1	PIN			2
1						-09A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMASTER-CARR #88625K67) MODIFIED	3
1	1	1	1	1	B/O	-11		DOWEL PIN	STEEL	Ø3mm X 40mm (MCMASTER-CARR #91595A142)	2
					B/O	-13	1	RE-SEALABLE PLASTIC BAG		5 IN X 6 IN APPROX.	N/S
A/R	A/R	A/R	A/R	A/R	B/O	-15		LOCTITE 680			2
1	1	1	1	1	B/O	-17		FLAGS, REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
1	1	1	1	1	B/O	-19		CABLE TIE	BLACK NYLON	(MCMASTER-CARR #7189K31)	2
ASSY -09	ASSY -07	ASSY -05	ASSY -03	ASSY -01							

			
TITLE			
RIGGING PIN SET			
DWG NO.			REV
RBE350A94-2706-00			6
MAT'L		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
HEAT TREAT			
FINISH			
SPEC			
DRAWN BY:		PERRITT	
CHECKED:		DUERFELDT	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:3	
DATE		9/11/2009	
SHEET		1 OF 3	

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
6	16-0281	-01, -03, -05, -07, -09 ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D. ADDED -17, -19, NOTE 1.			1/12/2017	RJC JAG



ASSY P/N	A P/N
-01	-01A
-03	-03A
-05	-05A
-07	-07A
-09	-09A

NOTE:

1 USE LOCTITE 680 TO ASSEMBLE.

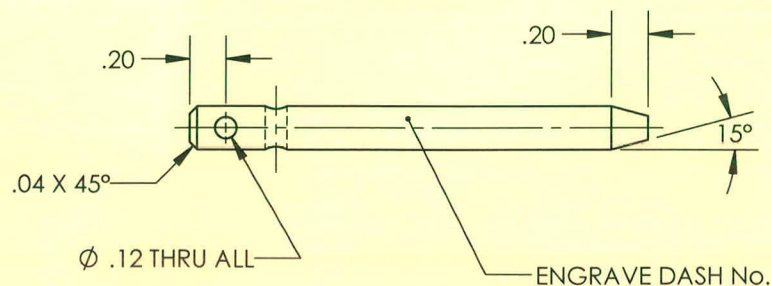
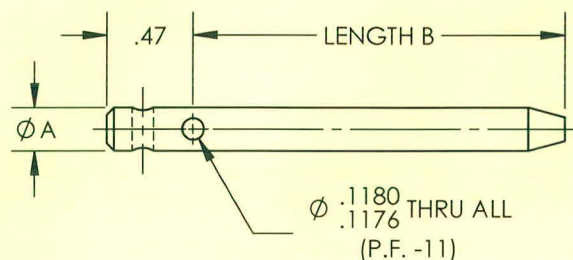
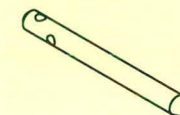
DART AEROSPACE	
TITLE RIGGING PIN SET	
DWG NO. RBE350A94-2706-00-01	REV 6
MAT'L HEAT TREAT FINISH SPEC DRAWN BY: CHECKED: OPPS APPR: QA APPR: APPROVED:	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EUROCOPTER AS350/355
BLACK OXIDE QMSI-6.2.2, B.O. REV D PERRITT DUERFELDT ANDERSON LINDSAY GILBERT	SCALE 1:3 DATE 9/11/2009 SHEET 2 OF 3

-01, -03, -05, -07, -09

PIN

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		MOVED LENGTH B DIMENSION TO Ø.118in. HOLE CENTERLINE & ADDED 1.5mm TO -.01 THRU -.09 PINS IN TABLE. ADDED A TOLERANCE TO Ø.118in HOLE TO ACHIEVE A LIGHT PRESS FIT FOR -.11. CH'D HOLE FROM Ø.118 TO Ø.113 FOR CABLE TIES @ END OF PIN PER S.E.	5/26/2015	RJC	RW
4	15-0120	CH'D TOLERANCE BLOCK WAS .XXX ± .004 IS .XXX ± .005.	5/26/2015	DPD	JAG
6	16-0281	-01A, -03A, -05A, -07A, -09A CH'D DIM WAS 2X Ø.118 +.001/-.000 THRU ALL IS Ø.1180/.1176 THRU ALL (P.F. -11). ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No., ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG



-01A, -03A, -05A, -07A, -09A

PIN SHAFT

ENGRAVE	PIN DIMENSION TABLE		
DASH No.	P/N	ØA	LENGTH B
-01	-01A	6mm	2.028
-03	-03A	8mm	5.177
-05	-05A	8mm	3.012
-07	-07A	6mm	4.783
-09	-09A	8mm	1.240

DART AEROSPACE	
TITLE RIGGING PIN SET	
DWG NO. RBE350A94-2706-00-01A	REV 6
MAT'L O-1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -01, -03, -05, -07, -09	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:1	DATE 9/11/2009
SHEET 3 OF 3	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
--------	---------	-----------------	-----------------------

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040821**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040821
PO Date: 8/23/18
Due Date: 8/28/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	179431	RBE350A93-3303-02-7	Stud Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/28/18	40 pcs	0 pcs	40 pcs	\$1.93548397/pcs	\$77.42
Line Item Note ** need back asap **											
2	180106	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/28/18	10 pcs	0 pcs	10 pcs	\$1.93548397/pcs	\$19.35
3	180114	RBE350A94-2706-00-09	Pin -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/28/18	3 pcs	0 pcs	3 pcs	\$1.93548397/pcs	\$5.81

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	180108	RBE350A94-2706-00-03	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/28/18	6 pcs	0 pcs	6 pcs	\$1.93548397/pcs	\$11.61
Line Item Note ** need back asap ** Advise ETA											
5	180112	RBE350A94-2706-00-07	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/28/18	3 pcs	0 pcs	3 pcs	\$1.93548397/pcs	\$5.81
Grand Total:											\$120.00

 DAS
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Order Notes

Procurement Quality Clauses
 A005 right of entry
 A012 chemical and physical test report
 A016 personnel qualification
 A017 raw material identification (as applicable)

A022 Apical Processing
 A024 process certifications
 A026 certification of material conformance

A041 quality management system
 A042 dart notification by supplier
 A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/27/18 9:50 AM dart.tsimiklis.chrisoula

CT



Certificat de Conformité / Certificate of Compliance

(012115-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

012115- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
30-Aug-2018		Aman		040821				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3303-02-7 Rev.	RBE350A93-3303-02-7 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	40	40	0	0	0
2	RBE350A94-2706-00-01 Rev.	RBE350A94-2706-00-01 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	10	10	0	0	0
3	RBE350A94-2706-00-09 Rev.	RBE350A94-2706-00-09 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	3	3	0	0	0
4	RBE350A94-2706-00-03 Rev.	RBE350A94-2706-00-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
5	RBE350A94-2706-00-07 Rev.	RBE350A94-2706-00-07 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	3	3	0	0	0

DAS
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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

